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**D2278**  
**Job Sheet 198926**

Part No: D2278

Job Qty: 60 pcs

Part Name: Step Leg



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 8/14/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev C New flat pattern 08.01.11 EC

Ship Via:

Bill of Materials

Job Routing

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Waterjet - Flow - 1 | 60 pcs |            | 8/14/19  | 0.01      | 6.73    | Waterjet - Flow       |           | 08/19/15 |
| 110   | QC 2                | 60 pcs |            | 8/14/19  | 0.00      | 0.00    | QC 2 - 1              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 12             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 14             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 17             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 19             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 2              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 20             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 22             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 23             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 25             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 32             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 33             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 35             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 39             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 4              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 40             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 44             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 45             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 48             |           | 08/19/15 |
|       |                     |        |            |          |           |         | QC 2 - 49             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 50             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 51             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 52             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 57             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 62             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 63             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 8              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 66             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 64             |           |          |

Rush !!!

|                                   |           |         |           |                           |  |
|-----------------------------------|-----------|---------|-----------|---------------------------|--|
| 120 QC 8                          | 60<br>pcs | 8/14/19 | 0.00 0.00 | QC 2 - 65                 |  |
|                                   |           |         |           | QC 2 - 5                  |  |
|                                   |           |         |           | QC 2 - 71                 |  |
|                                   |           |         |           | QC 2 - 73                 |  |
|                                   |           |         |           | QC 2 - 69                 |  |
|                                   |           |         |           | QC 8 - 12                 |  |
|                                   |           |         |           | QC 8 - 14                 |  |
|                                   |           |         |           | QC 8 - 17                 |  |
|                                   |           |         |           | QC 8 - 20                 |  |
|                                   |           |         |           | QC 8 - 25                 |  |
|                                   |           |         |           | QC 8 - 3                  |  |
|                                   |           |         |           | QC 8 - 32                 |  |
|                                   |           |         |           | QC 8 - 33                 |  |
|                                   |           |         |           | QC 8 - 35                 |  |
|                                   |           |         |           | QC 8 - 39                 |  |
|                                   |           |         |           | QC 8 - 4                  |  |
|                                   |           |         |           | QC 8 - 44                 |  |
|                                   |           |         |           | QC 8 - 45                 |  |
|                                   |           |         |           | QC 8 - 49                 |  |
|                                   |           |         |           | QC 8 - 58                 |  |
|                                   |           |         |           | QC 8 - 8                  |  |
|                                   |           |         |           | QC 8 - 9                  |  |
|                                   |           |         |           | QC 8 - 68                 |  |
|                                   |           |         |           | QC 8 - 67                 |  |
|                                   |           |         |           | QC 8 - 1 (A)              |  |
|                                   |           |         |           | QC 8 - 47                 |  |
|                                   |           |         |           | QC 8 - 40                 |  |
|                                   |           |         |           | QC 8 - 52                 |  |
|                                   |           |         |           | QC 8 - 23                 |  |
|                                   |           |         |           | QC 8 - 57                 |  |
| 130 Handfinish - 1-1 Chemical-B4B | 60<br>pcs | 8/14/19 | 0.00 1.58 | Handfinish - 1 - 1 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 2 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 3 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 4 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 5 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 6 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 7 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 8 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 9 - B4B  |  |
|                                   |           |         |           | Handfinish - 1 - 10 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 11 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 12 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 13 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 14 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 15 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 16 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 17 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 18 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 19 - B4B |  |
|                                   |           |         |           | Handfinish - 1 - 20 - B4B |  |

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BEB 19-08-19

|                                 |           |         |           |                           |              |
|---------------------------------|-----------|---------|-----------|---------------------------|--------------|
| 140 QC 7                        | 60<br>pcs | 8/14/19 | 0.00 0.00 | Handfinish - 1 - 21 - B4B |              |
|                                 |           |         |           | Handfinish - 1 - 22 - B4B |              |
|                                 |           |         |           | QC 7 - 10                 |              |
|                                 |           |         |           | QC 7 - 13                 |              |
|                                 |           |         |           | QC 7 - 14                 |              |
|                                 |           |         |           | QC 7 - 15                 |              |
|                                 |           |         |           | QC 7 - 17                 |              |
|                                 |           |         |           | QC 7 - 18                 |              |
|                                 |           |         |           | QC 7 - 19                 |              |
|                                 |           |         |           | QC 7 - 2                  |              |
|                                 |           |         |           | QC 7 - 28                 |              |
|                                 |           |         |           | QC 7 - 3                  |              |
|                                 |           |         |           | QC 7 - 30                 |              |
|                                 |           |         |           | QC 7 - 34                 |              |
|                                 |           |         |           | QC 7 - 36                 |              |
|                                 |           |         |           | QC 7 - 37                 |              |
|                                 |           |         |           | QC 7 - 41                 |              |
|                                 |           |         |           | QC 7 - 47                 |              |
|                                 |           |         |           | QC 7 - 48                 |              |
|                                 |           |         |           | QC 7 - 51                 |              |
|                                 |           |         |           | QC 7 - 58                 | smrs 19/8/19 |
|                                 |           |         |           | QC 7 - 59                 |              |
|                                 |           |         |           | QC 7 - 60                 |              |
|                                 |           |         |           | QC 7 - 9                  |              |
|                                 |           |         |           | QC 7 - 68                 |              |
|                                 |           |         |           | QC 7 - 50                 |              |
|                                 |           |         |           | QC 7 - 67                 |              |
|                                 |           |         |           | QC 7 - 40                 |              |
|                                 |           |         |           | QC 7 - 24                 |              |
|                                 |           |         |           | QC 7 - 43                 |              |
|                                 |           |         |           | QC 7 - 61                 |              |
|                                 |           |         |           | QC 7 - 81                 |              |
| 150 Packaging 3-1 - Stock - B4B | 60<br>pcs | 8/14/19 | 0.00 0.00 | Packaging 3 - 1 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 2 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 3 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 4 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 5 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 6 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 7 - B4B     | smrs 19/8/19 |
|                                 |           |         |           | Packaging 3 - 8 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 9 - B4B     |              |
|                                 |           |         |           | Packaging 3 - 10 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 11 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 12 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 13 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 14 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 15 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 16 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 17 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 18 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 19 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 20 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 21 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 22 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 23 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 24 - B4B    |              |
|                                 |           |         |           | Packaging 3 - 25 - B4B    |              |

|                |           |         |           |                        |  |
|----------------|-----------|---------|-----------|------------------------|--|
| 160 QC 21 - SA | 60<br>pcs | 8/14/19 | 0.00 0.00 | Packaging 3 - 26 - B4B |  |
|                |           |         |           | Packaging 3 - 27 - B4B |  |
|                |           |         |           | Packaging 3 - 28 - B4B |  |
|                |           |         |           | Packaging 3 - 29 - B4B |  |
|                |           |         |           | Packaging 3 - 30 - B4B |  |
|                |           |         |           | Packaging 3 - 31 - B4B |  |
|                |           |         |           | Packaging 3 - 32 - B4B |  |
|                |           |         |           | Packaging 3 - 33 - B4B |  |
|                |           |         |           | Packaging 3 - 34 - B4B |  |
|                |           |         |           | Packaging 3 - 35 - B4B |  |
|                |           |         |           | Packaging 3 - 36 - B4B |  |
|                |           |         |           | QC 21 - SA - 21        |  |
|                |           |         |           | QC 21 - SA - 70        |  |
|                |           |         |           | QC 21 - SA - 53        |  |

Part Op 100 - 1-Cut as per Dwg D2278  
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)  
120 - (QC8- Inspect parts - second check)  
130 - (Chemical Conversion Coat per QSI005 4.1)  
140 - (QC7-Inspect Chemical Conversion Coat)  
150 - (Identify as per dwg & Stock Location: ) LOCATION : GA 157F  
160 - (QC21- Final Inspection - Work Order Release)

| Job BOM      |                    |                       |                         |                    |
|--------------|--------------------|-----------------------|-------------------------|--------------------|
| Part / Item  | Component Name     | Quantity              | Operation               | Container          |
| M6061T6S.080 | 6061-T6 .080 Sheet | 58.8900 sf (.9815 ea) | 100-Waterjet - Flow - 1 | 5190196<br>5200297 |

| Job Allocations         |                |          |           |           |
|-------------------------|----------------|----------|-----------|-----------|
| Operation               | Component Part | Required | Inventory | Allocated |
| 100-Waterjet - Flow - 1 | M6061T6S.080   | 59       | 327       | 0         |

| Part Specifications |             |                                |                  |        |                  |
|---------------------|-------------|--------------------------------|------------------|--------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits           | Type   | Special Comments |
| 1                   | Leg         | 0.354Inches ± 0.010            | 0.364<br>0.344   |        |                  |
| 2                   | Leg         | 0.354Inches ± 0.010            | 0.364<br>0.344   |        |                  |
| 3                   | Leg         | 16.460Inches ± 0.030           | 16.490<br>16.430 |        |                  |
| 4                   | Leg         | 0.128Inches + 0.005<br>- 0.000 | 0.133<br>0.128   |        |                  |
| 5                   | Leg         | 0.354Inches ± 0.030            | 0.384<br>0.324   | Radius |                  |
| 6                   | Leg         | 2.000Inches ± 0.030            | 2.030<br>1.970   |        |                  |
| 7                   | Leg         | 4.740Inches ± 0.030            | 4.770<br>4.710   |        |                  |
| 8                   | Leg         | 8.460Inches ± 0.030            | 8.490<br>8.430   |        |                  |
| 9                   | Leg         | 0.213Inches ± 0.010            | 0.223<br>0.203   |        |                  |
| 10                  | Leg         | 0.750Inches ± 0.010            | 0.760<br>0.740   |        |                  |
| 11                  | Leg         | 0.080Inches ± 0.010            | 0.090<br>0.070   | thick  |                  |

Plex 8/7/19 2:19 PM dart.leroux.jason